

Date: Thursday, 4/12/2007 9:34:45 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER	
Job Number	: 31794B		Part Number	: D30653	
Estimate Number	: 10378		Drawing Number	: D3065 REV. B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/12/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/15/2007	
Previous Run	: 31339B		Qty:	60	Um: Each
Written By					
Checked & Approved By					
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet Comment: Qty.: 0.2287 sf(s)/Unit Total : 13.7214 sf(s) 103039 x 34 7.7158 Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: M103321 x 26 5.9462 <i>ml 07 05 01</i> (60)
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <i>ml 07 05 01</i> (60)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 07 05 01</i> (60) Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>ml 07 05 08</i> (60) Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>ml 07 05 09</i> (59) Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/08	2.0	one part made in water jet when cutting	/ as1042	one part shape	SAD 07/05/08	M 07/05/08	/ as1042	M 07/05/08

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 31794B

Part Number: D30653

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D30653

SB 27/06/04

(59)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Do 06/07



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS/

07-06-11

(59)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

MF.

07-06-11

(59)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF

07-06-11

(59)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31794B
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

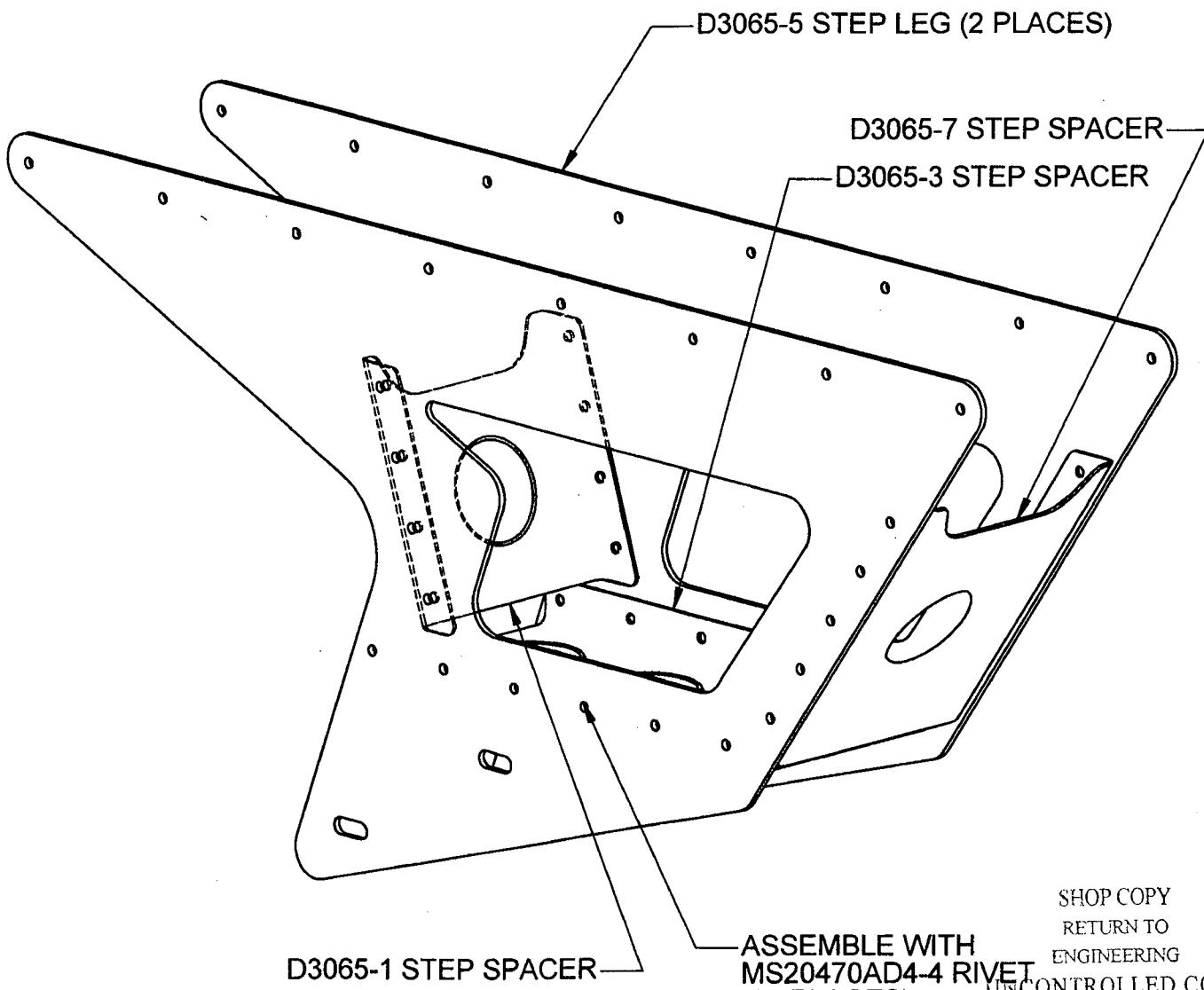
X First Article Prototype

Measured by:	M. M	Audited by:		Prototype Approval:	N/A
Date:	07/05/07	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20 [Signature]*

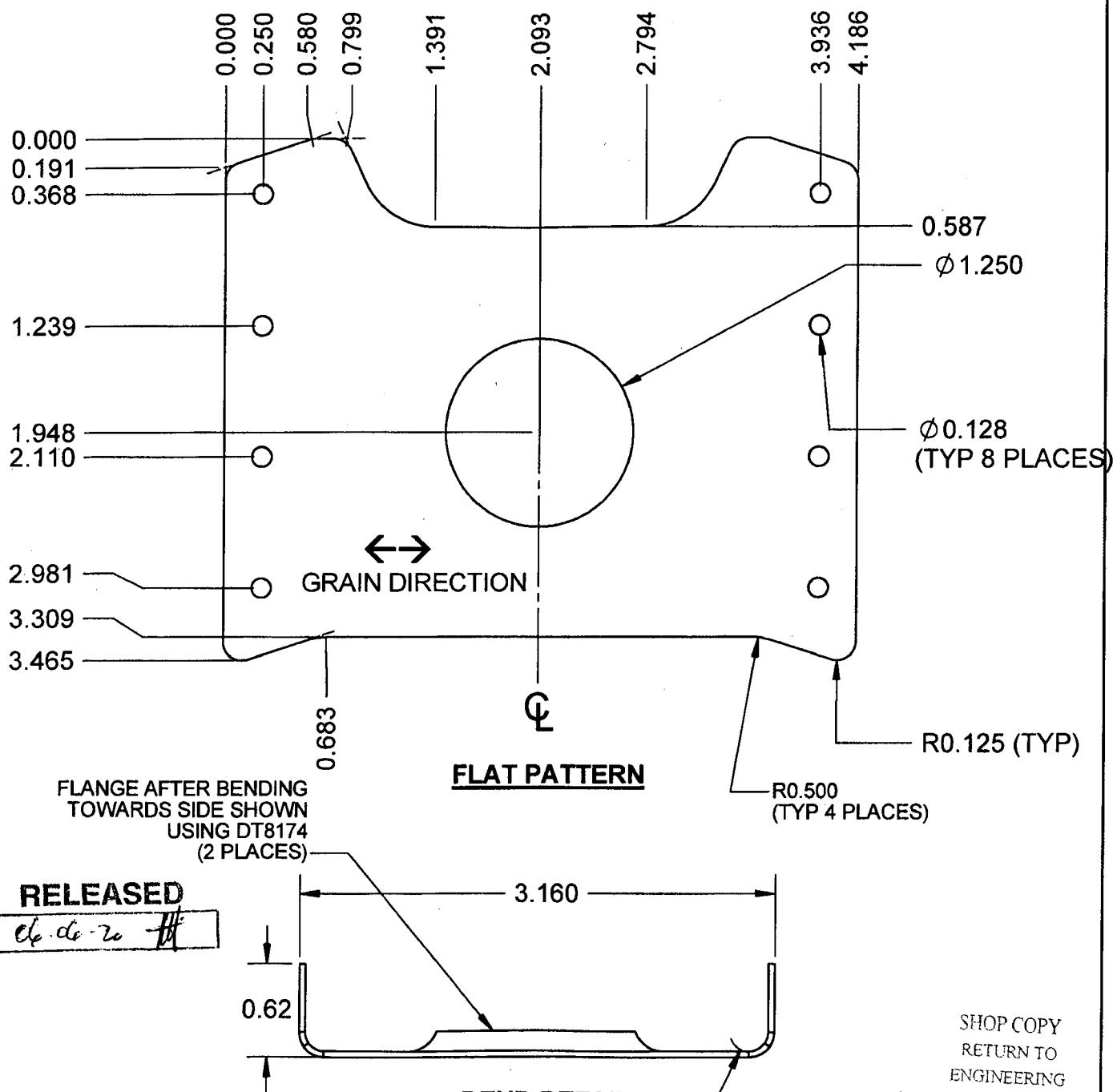
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D3065-041 STEP LEG ASSEMBLY**COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

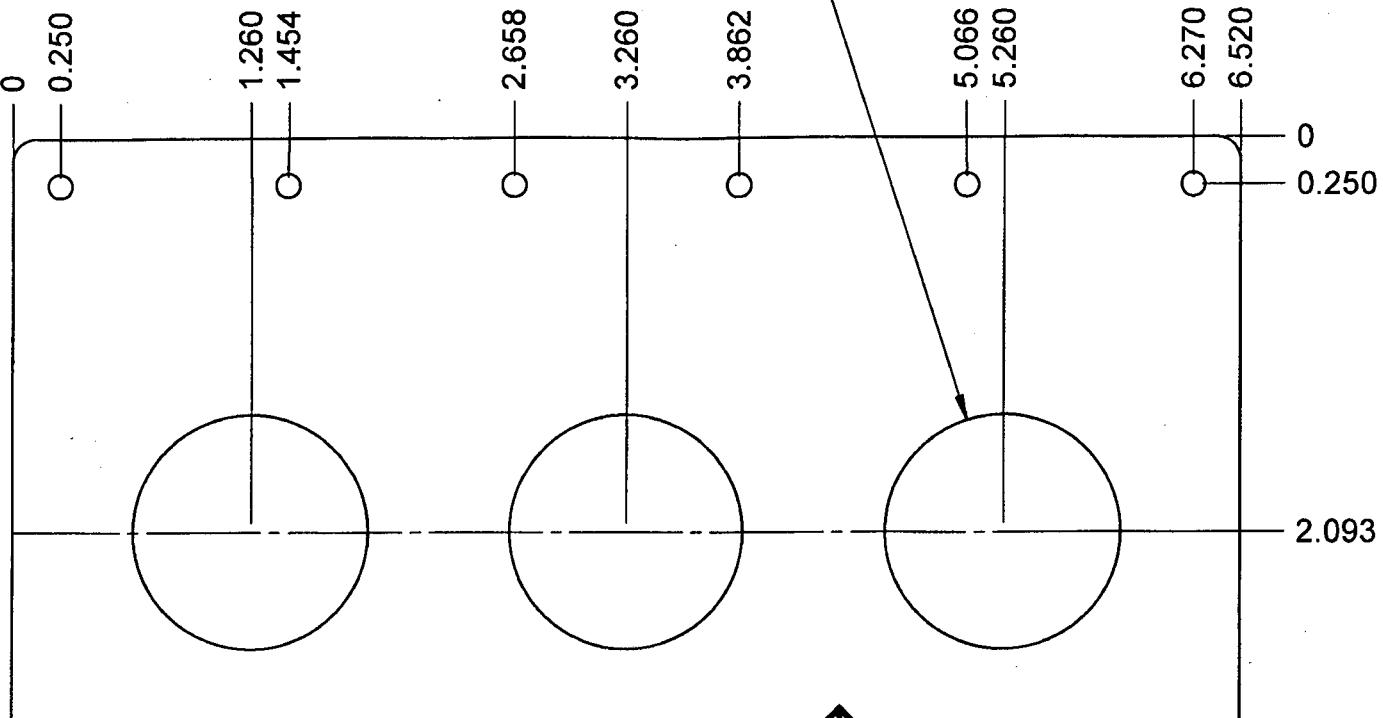
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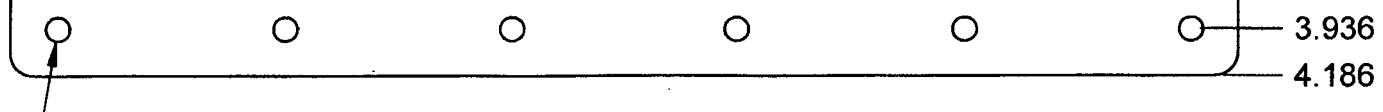
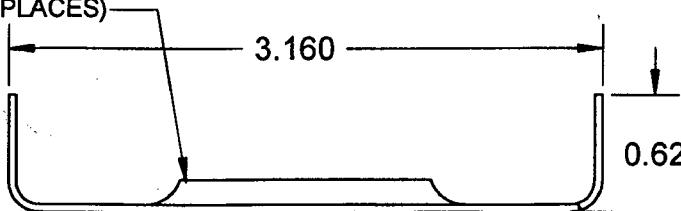
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

 $\phi 1.250$ (TYP, 3 PLACES)FLAT PATTERN

↔ GRAIN DIRECTION

FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$ (TYP, 12 PLACES)**RELEASED***06 Oct 20 - MM*BEND DETAIL

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WORK ORDER

NO. 31794/B**D3065-3 STEP SPACER**

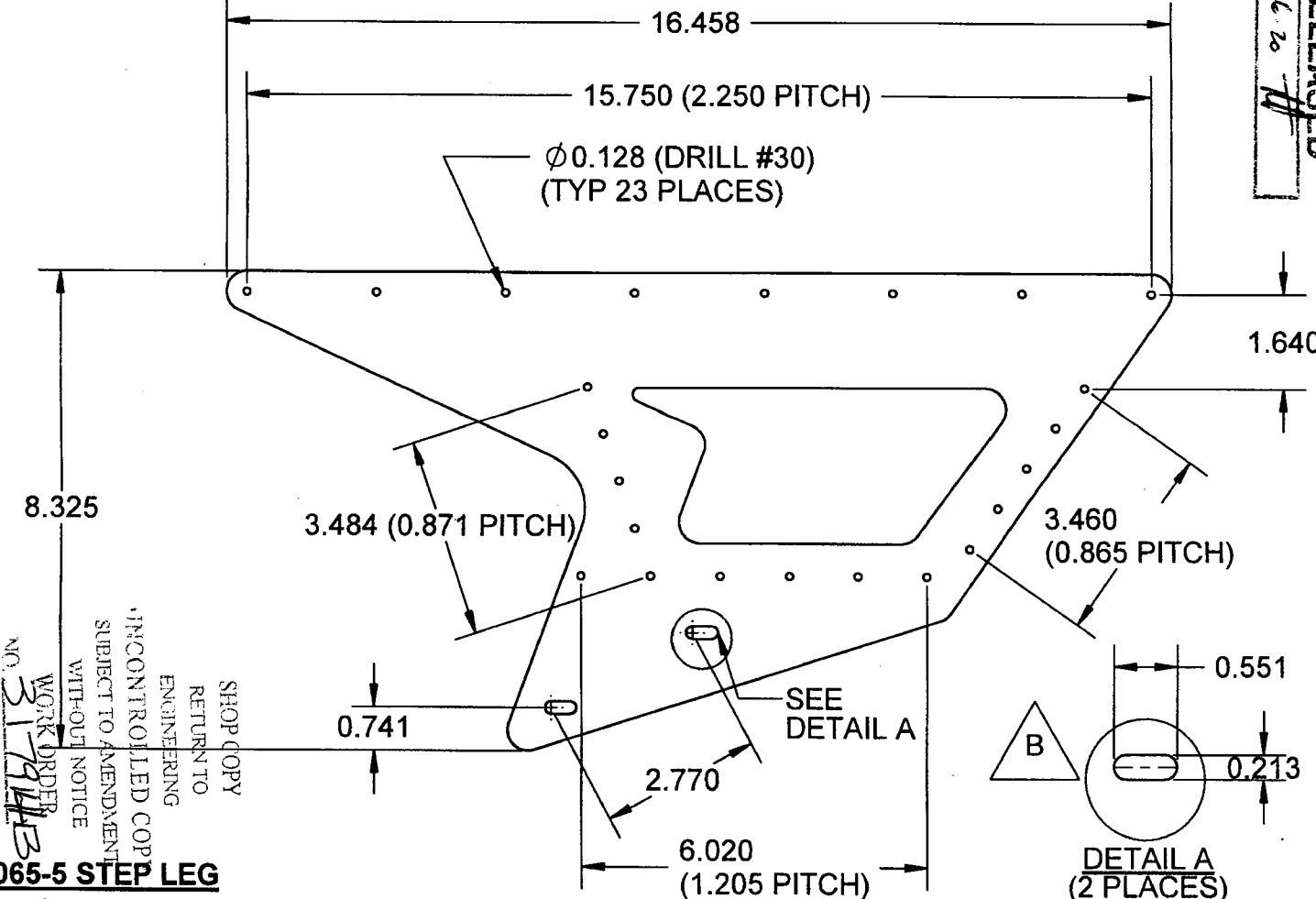
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065
DATE 06.05.23		TITLE STEP LEG ASSEMBLY

RELEASED
6.6.22 H**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

